

Date: Tuesday, 7/17/2007 2:01:50 PM  
User: Kim Johnston

## Process Sheet

split w/o  
8/08/01/25

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : N1 GEARBOX ACCESS PANEL KIT  
Job Number : 33603  
Estimate Number : 12503  
P.O. Number :  
This Issue : 7/17/2007 S.O. No. :  
Prsht Rev. : NC Part Number : D3255041  
First Issue : 11 Type : LARGE FAB ASSY Drawing Number : D3255 REV B  
Previous Run : 28831 Project Number : N/A  
Material : B  
Written By : Due Date : 8/20/2007 Qty: 4 Um: Each  
Checked & Approved By : 07.07.17  
Comment : Est Rev: C Removed Manufacturing of D3255-1/-2/-3 06-08-02  
JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D32551 Panel



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Panel

Batch: 333605 ✓

07.11.01

2.0 D32553 Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Cap

Batch: M21863 ✓

07.11.01

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D3255

A/R SS ROD Batch: M105138

2-Grind Welds Flush

07.11.01

4.0 DO NOT USE WELD INSPECTION



Comment: WELD INSPECTION

07.11.05 (4)

5.0 POWDER COATING POWDER COATING





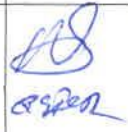

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref. 4.3.5.6) as per QSI 005 4.3

08/01/25 (1)  
07/11/06 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: D Date: 08/01/30  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/01/25	#70	Docking assembly if was found that there was dust under the Dasher with R.L. wasn't cleaned correctly Hammann error		<del>was said</del> Remove dust build up with (1200) touch up with paint	M. K. 08/01/25	 08/01/25		 08/01/25

NOTE: Date & initial all entries



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Drawing Name: N1 GEARBOX ACCESS PANEL KIT

Job Number: 33603

Part Number: D3255041

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*M-H*

*07/11/06*

*4X*

7.0

D32555

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Gasket

Batch: *333607*

*SB*

*08/01/25*

*4*

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Bond D3255-5 gasaket to d3255-041 using Dow coming adhesive as per Dwg D3255

A/R: 736

DOW CORNING ADHESIVE Batch: *M 105846*

*08/01/28*

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*SB 08/01/28*

*1*

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *180*

*8/1/28*

*50 (1X)*

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*08/01/30*

Job Completion



*2008/1/28*

*1X*

*W*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

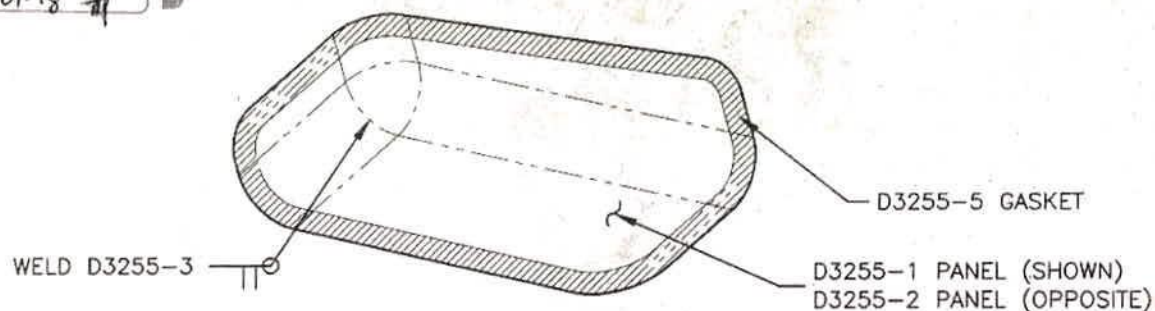
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
7/11/12	7	1 piece D3255-5 B33607 was bad cut		Scrap + destroy no replace	<i>[Signature]</i> 7/11/12			

NOTE: Date & initial all entries

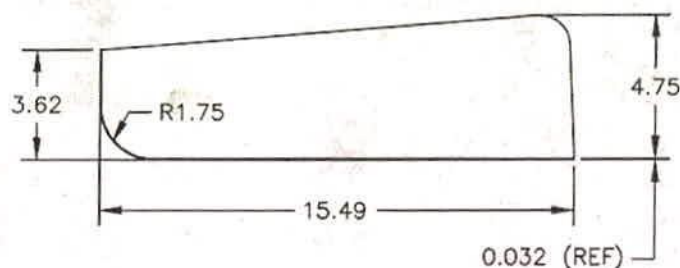
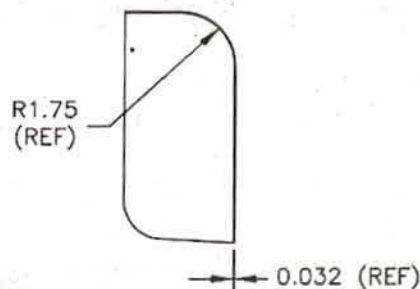
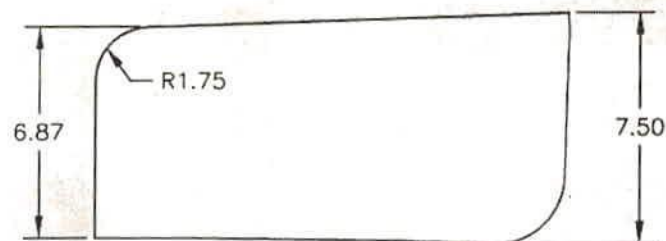


**DART**

DESIGN TH	DRAWN BY TH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED UP	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 1 OF 4
DATE 04.12.06	TITLE ACCESS PANEL ASSEMBLY		SCALE 1:6
A	04.01.27	NEW ISSUE	
B	04.12.06	D3255-3 REDESIGN; ADDED $\phi 0.098$	

RELEASED  
05-01-18 #

**D3255-041 ACCESS PANEL (SHOWN)**  
**D3255-042 ACCESS PANEL (OPPOSITE)**



**D3255-1 BEND DETAIL**  
**D3255-2 OPPOSITE**

**D3255-041/-042 NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

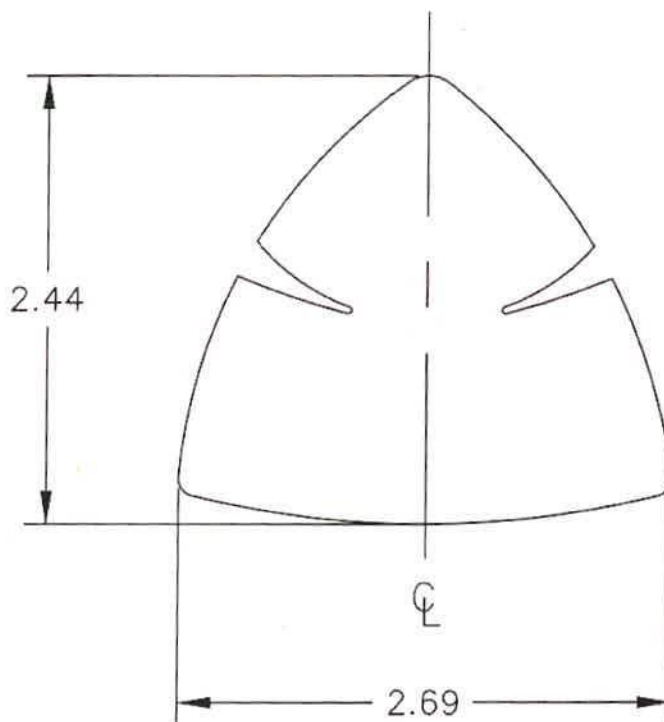
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DATE 04.12.06		TITLE TITLE	SCALE 1:1

**RELEASED**  
05-01-18 [Signature]

**D3255-3 CAP**  
**FORM TO FIT D3155-1/-2**

**D3255-3 NOTES:**

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

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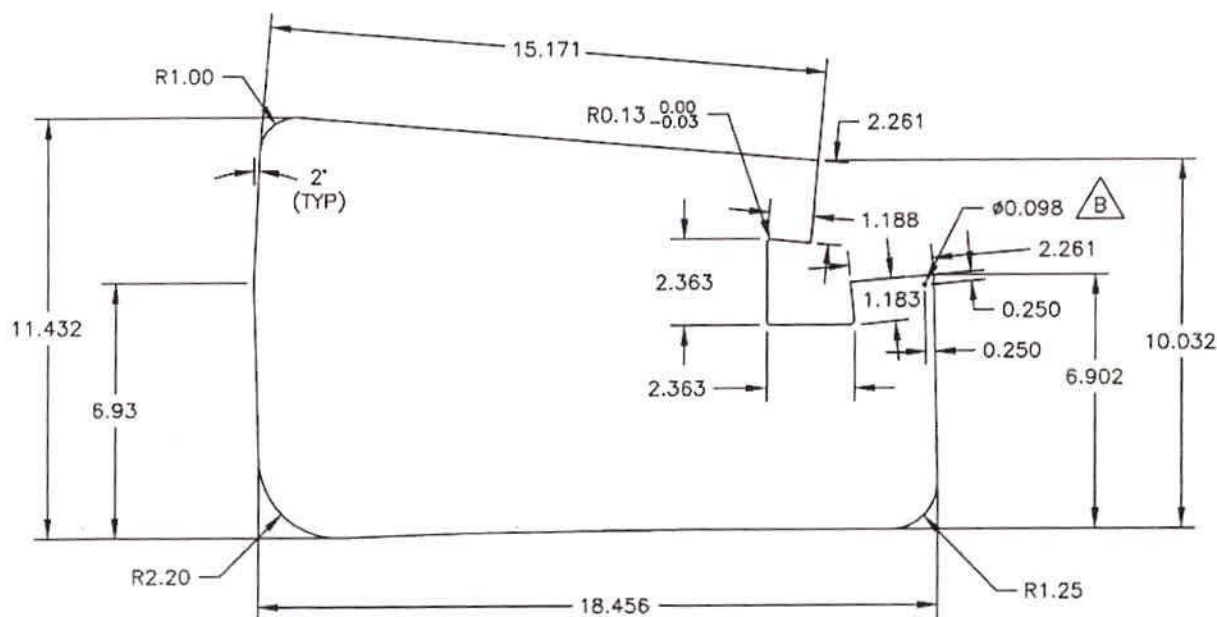
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DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

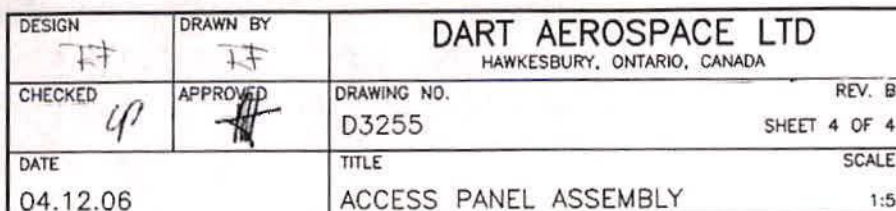
RELEASED  
05-01-18**D3255-1/-2 FLAT PATTERN****D3255-1/-2 NOTES:**

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

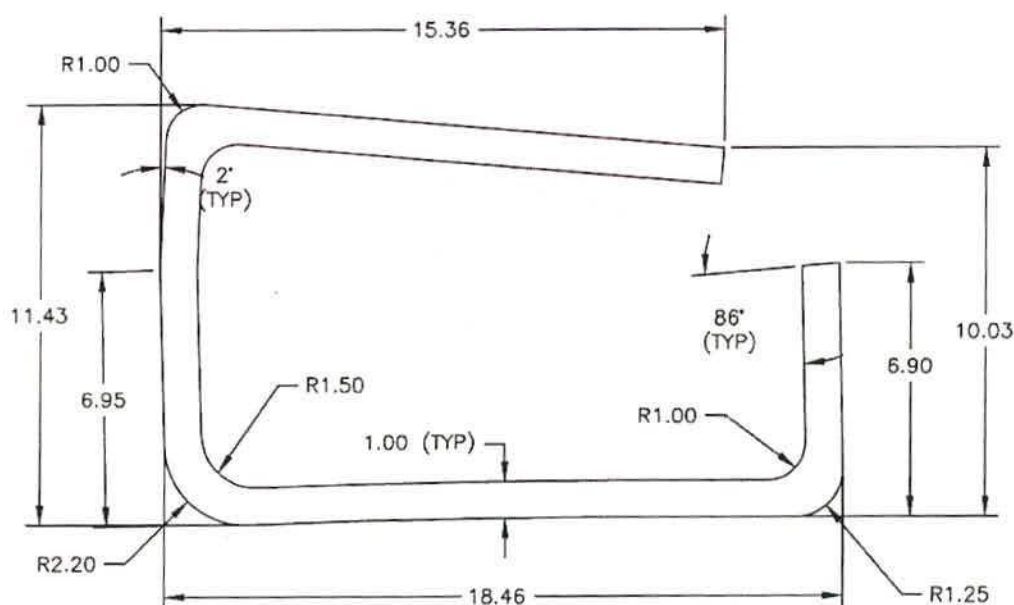
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RELEASED  
05 01 18 ~~11~~



D3255-5 NOTES:

- 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F  
P/N SIL/F 36x36x1/16  
POSSIBLE SUPPLIER: AVIALL
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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